

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008194**Date Inspected:** 30-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Peng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**SAW Process:**

Welding of weld joint# 1A located on PCMK ESD1 A65-A/B. Welder is identified as 041716. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U3c-S-2.

Welding of weld joint# 25A located on PCMK ESD1 A65-A/B. Welder is identified as 047304. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U3c-S-2.

**SMAW Process:**

Welding of weld joint# 3 located on PCMK WSD1 TL6 C/L. Welder is identified as 040690. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2-a-2.

Welding of weld joint# 113 located on PCMK WSD1 TL6 C/L. Welder is identified as 040733. ZPMC QC is

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identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2-a-2.

Welding of weld joint# 1 located on PCMK WSD1 TL6 F/L. Welder is identified as 049099. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2-a-2.

FCAW Process:

Welding of weld joint# 5 located on PCMK WSD1 FCSA4-2 B/C. Welder is identified as 068865. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 6 located on PCMK WSD1 FCSA4-2 B/C. Welder is identified as 066882. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 19 located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 068206. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 20 located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 066471. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 2 located on PCMK WSD1 FCSA4-2 B/C. Welder is identified as 068864. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 3 located on PCMK WSD1 FCSA4-2 B/C. Welder is identified as 066683. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 5 located on PCMK WSD1 FCSA4-2 B/C. Welder is identified as 062126. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 5 located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 068923. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 6 located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 069043. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

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### Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1- TL6 B/L 5 A/B 8237 HD 2

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversation

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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